

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022021**Date Inspected:** 06-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

ULTRASONIC TESTING

ZPMC NWIT No: 08473

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13East. The weld designations are as follows:

SEG3009E-149, 150, 154, 155

SEG3007C-218, 217, 328

SEG3007J-060~063

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050232 performing the Shielded Metal Arc Welding process on weld 097 located at PCMK SEG3019AW. ZPMC QC Mr. Zhang Qiang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 250 located at PCMK SEG3019P. ZPMC QC Mr. Zhang Qiang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070007 performing the Shielded Metal Arc Welding process on weld 162 located at PCMK SEG3019P. ZPMC QC Mr. Zhang Qiang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Weld repair report identified as B-WR20247.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066163 performing the Shielded Metal Arc Welding process on weld 084 located at PCMK SEG3019M. ZPMC QC Mr. Zhang Qiang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Weld repair report identified as B-WR20248.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066439 performing the Flux Cored Arc Welding process on weld 004 located at PCMK SEG3019U. ZPMC QC Mr. Zhang Qiang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066763 performing the Flux Cored Arc Welding process on weld 028 located at PCMK SEG3019M. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066236 performing the Flux Cored Arc Welding process on weld 002 located at PCMK SEG3019C. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066733 performing the Flux Cored Arc Welding process on weld 036 located at PCMK SEG3019AG. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials

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for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer